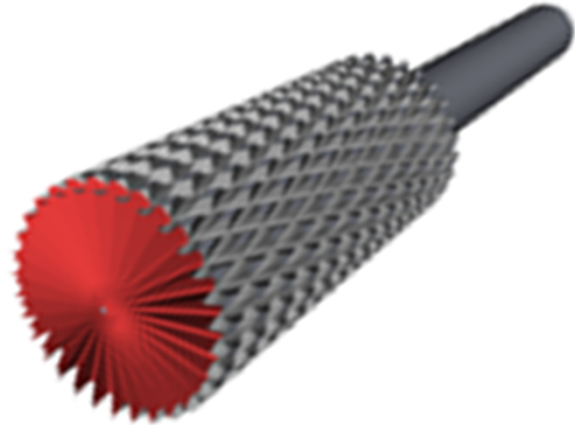







Burr Ø2.3 Z20

A11-011

This burr Ø2.3mm is ground from a solid carbide blank. The requested geometry of all 20 teeth including face teeth, is achieved with a 1V1 wheel.



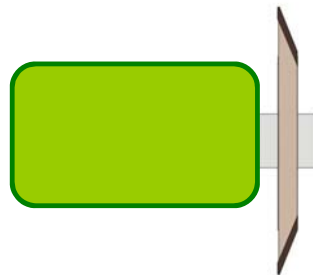
1. Cycletime for Production

Workpiece: Diameter 2.3 mm, Z 20, L14 mm, Helix angle 20° Material CARBIDE			
Operations			
	Probe	Flute 1	Flute 2
Feed [mm/Min]	2000	200	200
Power [kW]		1	1
Cutting speed [m/s]		32	32
Used wheels			
		1	1
Grinding time [s]	6	165	165
Total cycle time	5 Min 35		

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1V1 Ø60 D64
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3. Machine and Software Requirements

Machines: 5 axes CNC grinder : Aries ENP

Control: Fanuc 31i

Accessories:

Responsible engineer: SIW. 05.13

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5

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J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, China

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